Work Order ID 69 Thursday, May 12, 2011 3:2						Shi	D D	Page 1
Item ID: D3372-1 Revision ID:			Accept			Se	etup Start	
Item Name: Main Body							Stop	
Start Date: 5/13/2011 Required Date: 5/20/2011 Reference:	Start Qty: 4.00 Req'd Qty: 4.00	× 1111 111 111		Cust Item II Customer:	D:			
Approvals: Process Pl	an: MF	Date: 11-05	Tooling:	Da	te:	R	un Start	
QC:		Date:	SPC (Y/N):	Da	te:		Stop	
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool # Plan Code	Accept Qty		Reject Insp. Number Stamp
Draw Nbr Re	vision Nbr							
D3372 Re	vВ	<i>r</i>				· 		
100 Bandsaw Jeaspa Bandsaw	BAND SAW Memo Cut blank: 1	.500" x 3.000" x 4.450'	0.00 long	2-11/05/18		4	Ø	
						*	To the second se	
110 HAAS 1	HAAS CNC VERTICAL	MACHINING #1	0.00	A 11/05/	18 m	4	4	
HAAS CNC vertical machine #1	Machine D3 Identify as E Deburr	372-1 as per Folio FA49 33372-1	6 and Dwg D3372	· '				
	QC2- Inspect parts off m	achine FAI/FAIB	0.00	A 11/05/19		4	Ø	
QC	Memo	i	0.00	•	•			

Quality Control

Dail Aciospace Liu	Dart	Aeros	pace	Ltd
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W/O:			V	ORK ORDER CHA	ANGES					
DATE	STEP	PRO	CEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	: <u></u>	PAR #:	Fault Ca	tegory:	NC	R: Yes	No DQ	A:	_ Date: _	
	R	esolution:	Disposit	ion:	QA	: N/C C	losed:		Date: _	
NCR:		V	VORK OR	DER NON-CONFO	RMANCE	E (NC	R)			
DATE	STEP	Description of NC	Initial	Corrective Action Action Descrip	Section B	Sign		cation	Approval	Approval
		Section A	Chief Eng	Chief Eng	11011	Date	Sect	tion C	Chief Eng	QC Inspector
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				·						
<u></u>										
li .			1							

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 69631

Thursday, May 12, 2011 3:24:03 PM



Page 2

Item ID:

D3372-1

Accept

Setup Start

Stop



Revision ID:

Item Name:

Main Body

5/13/2011 Start Qty: 4.00

Date: _____

Cust Item ID:

Customer:

Reference:

Start Date:

Approvals:

Process Plan:

Date: Tooling:

Date:

Start Run



Required Date: 5/20/2011

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID

130

QC

Operation

QC: ____

Req'd Qty: 4.00

Memo

Set Up/ **Run Hours** Tool ID

Tool # Plan Code Accept Qty **Qty**

Reject Reject Number

Insp. Stamp

Quality Control

Description

QC8- Inspect parts - second check

0.00

0.00

ml 11/05/19

140

HandFinish

Hand Finishing

Chemical Conversion Coat per OSI005 4.1

0.00

Memo

0.00

150



Powder Coating

N/ 102391

Fire Red(Ref:4.3.5.10) per QSI005 4.3

0.00

Memo

0.00

Mask all holes and interior of the big hole

START TIME: OVEN TEMPERATURE:

FINISH TIME:

4x & M-11/05/20

W/O:			W	ORK ORDER CH	ANGES					
DATE	STEP	PRO	OCEDURE CHA	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							<u></u>		Prod Mgr	<u> </u>
							(4.20)			
Part No	•	PAR #:	Fault Cate	egory:	NC	R: Yes	No DQ	A:	_ Date: _	
	Re	esolution:	Disposition	on:	Q <i>A</i>	A: N/C Clo	sed:		Date: _	
NCR:			WORK ORD	ER NON-CONFO	RMANC	E (NCR)			
DATE	OTED	Description of NC		Corrective Action	Section B		Verifi	cation		Approval
DATE	STEP	Section A	Initial Chief Eng	Action Descrip Chief Eng	tion	Sign & Date		ion C	Chief Eng	QC inspector
							ľ			
									,	

Work Order ID 69631

Thursday, May 12, 2011 3:24:03 PM



Page 3

Item ID:

D3372-1

Accept

Setup Start

Stop



Revision ID:

Item Name: **Start Date:**

Main Body

5/13/2011

Start Qty: 4.00

Req'd Oty: 4.00

Operation

Description



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Set Up/

Run Hours

Date:

Run

Start

Stop



Required Date: 5/20/2011

Date:

SPC (Y/N):

Date:

Tool ID

Tool # Plan

Code

Reject Qty

Reject Number

Insp. Stamp

Sequence ID/ **Work Center ID**

160

QC

QC3- Inspect Part Finish

Memo

0.00

0.00

Accept

Qty

Quality Control

170

Packaging

Identify as per dwg & Stock Location:

0.00

0.00

Si 11/0 s/24

Packaging

180

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

Memo

0.00

MF (1-05-24

	•				1						
W/O:			W	ORK ORDE	R CH	ANGES		•			
DATE	STEP	PRO	OCEDURE CH	ANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			· · · · · · · · · · · · · · · · · · ·					·····			
Part No	:	PAR #:	Fault Cat	tegory:		NC	R: Yes	No DQ	A :	_ Date: _	
	R	esolution:	Dispositi	ion:	s	QA	: N/C CId	sed:		Date: _	·
NCR:			WORK ORI	DER NON-C	ONFO	RMANCE	(NCR)			
DATE	STEP	Description of NC		Corrective A		Section B	0:		cation	Date:	Approval
DAIL	JILF	Section A	Initial Chief Eng		Descript	tion	Sign & Date	Sect	ion C	Chief Eng	QC Inspector

Picklist Print

Thursday, May 12, 2011 3:23:58 PM

Work Order ID: 69631

Parent Item: D3372-1

Parent Item Name: Main Body



Start Date: 5/13/2011

Required Date: 5/20/2011

Page 1

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP A□05.01.18□New issue□KJ/JLM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B30000X01.5		Purchased	No			100	f	24.1670	0.375	1.578947	7		

. I TARAKAN DA BUMA BANTA KURU MANDA MA BUMAN BARA MUNIKARNI BANTA BANTA BANTA BANTA MARA MANDA BANTA BANTA BAN

6061-T6 Bar 3.00 x 1.50

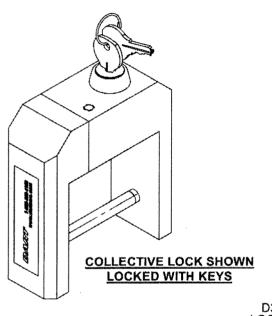
Location	Loc Qty	Loc Code
MAT010	24.167	
109058	1.667	
114468	10.5	
117653	12	

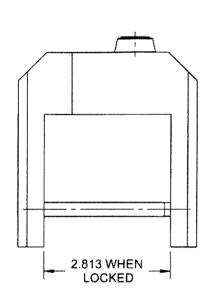
1.579 and 11/05/18

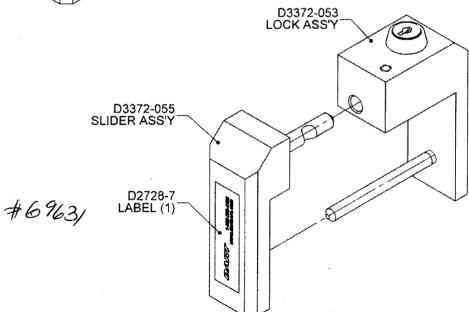
W/O:			W	ORK ORDER CH	ANGES				****	
DATE	STEP	PRO	CEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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:										
•										
Part No		PAR #:	_ Fault Ca	tegory:	NC	R: Yes I	Vo DQ	A:	_ Date: _	
	R	esolution:	Disposit	ion:	QA	: N/C Clo	sed:		Date: _	·
NCR:		V	VORK OR	DER NON-CONFO	RMANC	(NCR)			
DATE	STEP	Description of NC		Corrective Action	Section B	1 0: 0	Verific	cation	Approval	Approval
DAIL	SILP	Section A	Initial Chief Eng	Action Descrip Chief Eng	otion 	Sign & Date	Sect	ion C	Chief Eng	QC Inspector
								······	:	
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DESIGN	DRAWNB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECK	ED APPROVE	1 " 1\L.V. D
TA TA	1/1/1/	D3372 SHEET 1 OF 8
DATE	w.	TITLE · SCALE
	05.02.23	COLLECTIVE LOCK 1:2
Α	05.01.10	NEW ISSUE
В	05.02.23	REDESIGN FOR STANDARD 1/4 TURN LOCK, D3369-5 SUPERCEDES D3372-11 (OBSOLETE)









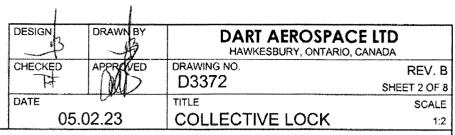
D3372-051 AS350 COLLECTIVE LOCK ASS'Y

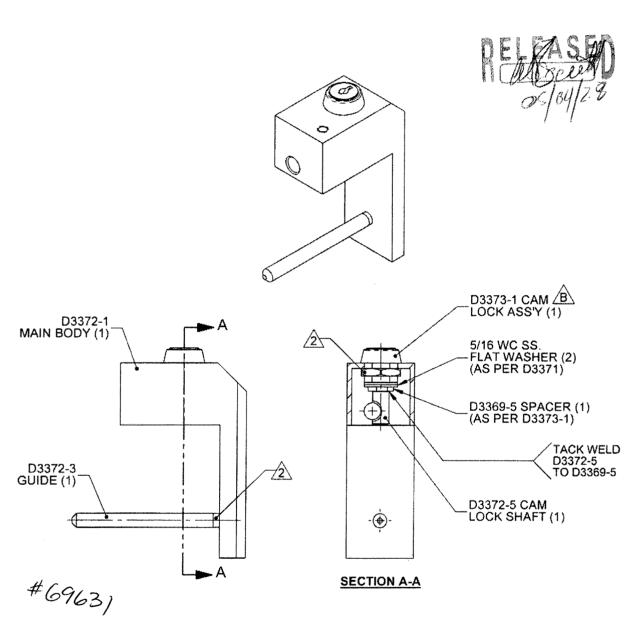
NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 2) ALL DIMENSIONS ARE IN INCHES
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W/O:				V	VORK ORDER CHANGES	3				
DATE	STEP	PRO	CEDUR	E CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Faul	t Ca	tegory: l	NCR: Yes	No E	QA:	_ Date: _	
	Re	esolution:	Disp	osit	ion: (QA: N/C	Closed:		Date: _	
NCR:		W	ORK	OR	DER NON-CONFORMAN	CE (NC	R)			
DATE	OTED	Description of NC			Corrective Action Section 6		Vei	rification		Approval
DATE	STEP	Section A	Init i Chief		Action Description Chief Eng	Sign Dat	& S	ection C	Chief Eng	QC Inspector







D3372-053 LOCK ASS'Y

NOTES:

- 1) WELD PER DART QSI 004 2) APPLY THREADLOCKER LOCTITE 262 ON THREADS

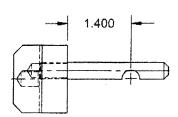
COPYRIGHT © 2005 BY DART AEROSPACE LTD.

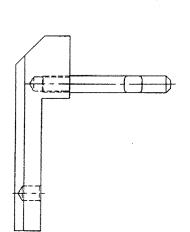
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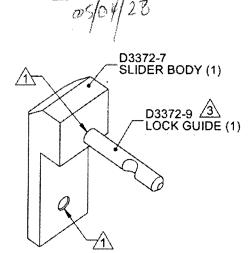
Dart Ae	rospace l	_td								
W/O:				WO	RK ORDER CHANGES					
DATE	STEP	PRC	CEDURE	CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault	Categ	ory: N	CR: Yes	No DQ	A:	Date: _	
	Res	solution:	Disp	psition	: Q	A: N/C C	osed:		Date: _	
NCR:		\	VORK (ORDE	R NON-CONFORMANC	E (NCF	₹)			,
DATE	STEP	Description of NC	Initia		Corrective Action Section B Action Description	Sign		cation	ation Approval Approv	Approval
		Section A	Chief E		Chief Eng	Date		ion C	Chief Eng	QC Inspector
										



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CHECK	ED APPRO	(A) } }	DRAWING NO.	REV. B SHEET 3 OF 8
DATE	05.02.23		COLLECTIVE LOCK	SCALE 1:2







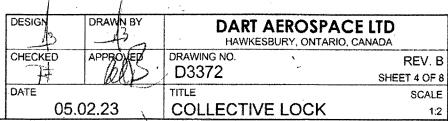


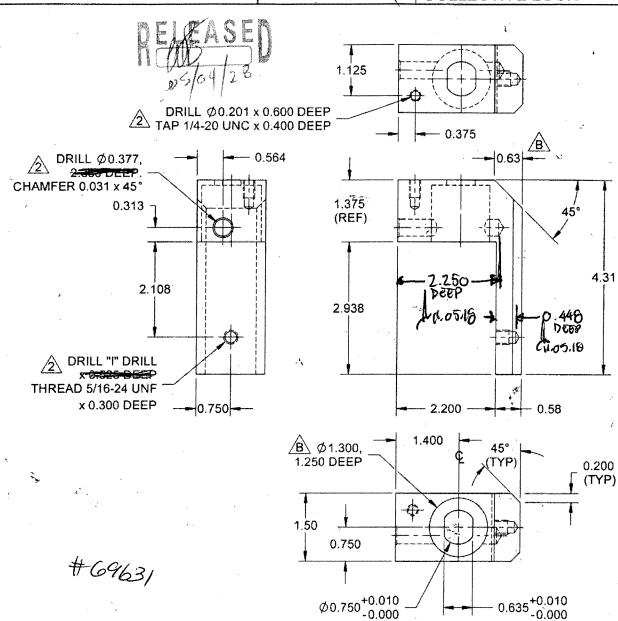
D3372-055 SLIDER ASS'Y

NOTES:

- 1) COVER INSIDE HOLES AND D3372-9 PRIOR PAINTING
 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
 3) APPLY THREADLOCKER LOCTITE 262 ON D3372-9 THREADS PRIOR ASSEMBLY
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 5) ALL DIMENSIONS ARE IN INCHES







D3372-1 MAIN BODY

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
 (REF. DART SPEC. M6061T6B)
 2) COVER INSIDE HOLES PRIOR PAINTING
 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 5) ALL DIMENSIONS ARE IN INCHES

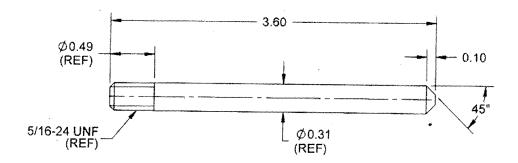
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010



DESIGN	DRAWN BY	DART AEROSPAC HAWKESBURY, ONTARIO, O	
CHECKED 1	APPROVED	D3372	REV. B
DATE 05	.02.23	COLLECTIVE LOCK	SCALE

SPECIFICATION CONTROL DRAWING





#69631

D3372-3 GUIDE

NOTES:

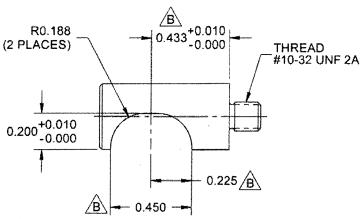
- 1) MATERIAL: AN5-42A BOLT MODIFIED AS SHOWN.
 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 3) ALL DIMENSIONS ARE IN INCHES
 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

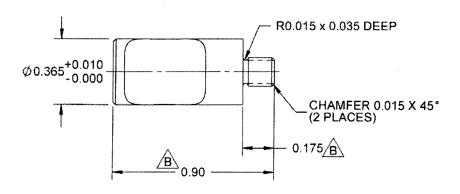
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<u> </u>		D3372	SHEET 6 OF 8
DATE	1.0	TITLE	SCALE
05	.02.23	COLLECTIVE LOCK	2:1







#6963)

D3372-5 CAM LOCK SHAFT

NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375) 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 3) ALL DIMENSIONS ARE IN INCHES 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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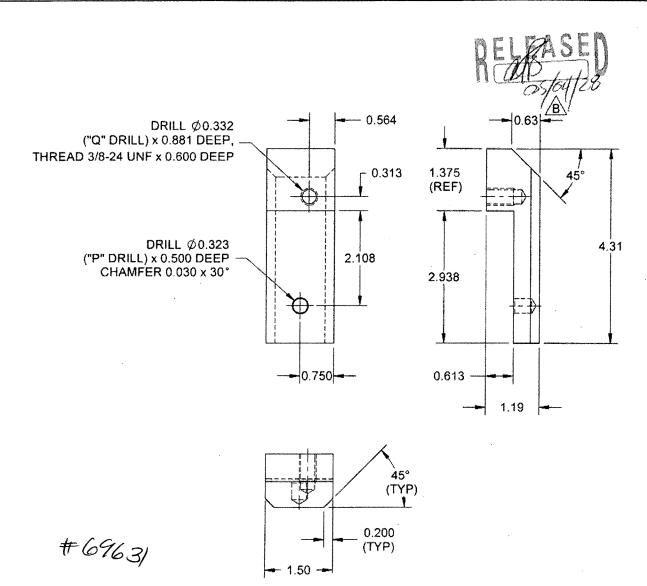
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DESIGN	DRAWN BY	DART AEROSPAC HAWKESBURY, ONTARIO, (
CHECKED	APPROVED	DRAWING NO.	REV. B
<u> </u>	1/4/1/2	D3372	SHEET 7 OF 8
DATE	0010	TITLE	SCALE
05	.02.23	COLLECTIVE LOCK	1:2



D3372-7 SLIDER BODY

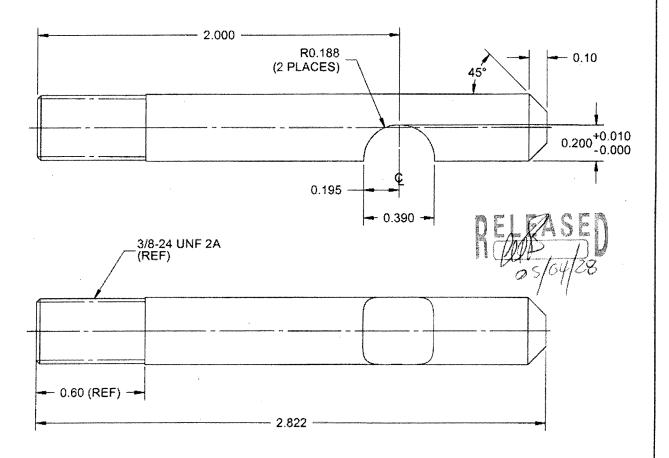
NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
 (REF, DART SPEC. M6061T6B)
 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) ALL DIMENSIONS ARE IN INCHES
 5) BREAK ALL SHARP EDGES 0.005 TO 0.010



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DESIGN	DRAWN BY	DART AEROSPAC HAWKESBURY, ONTARIO,	
CHECKED	APPROVED	DRAWING NO.	REV. B
一持		D3372	SHEET 8 OF 8
DATE	V	TITLE	SCALE
05.	.02.23	COLLECTIVE LOCK	2:1

SPECIFICATION CONTROL DRAWING



#69631

D3372-9 LOCK GUIDE

NOTES:

- 1) MATERIAL: AN6-36A BOLT, MODIFIED AS SHOWN 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 3) ALL DIMENSIONS ARE IN INCHES 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

DART AEROSPACE LTD	Work Order:	69631
Description: Main Body	Part Number:	D3372-1
Inspection Dwg: D3372 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.377	+0.005/-0.000	\$ 0.382	~		Vein	GA-0)
0.313	+/-0.010	0.312	~		11	1/
0.750	+/-0.010	0.752	~		11	"
1.375	+/-0.010	1.375	~		11	"
2.938	+/-0.010	2.938	1		4-6	31006
2.200	+/-0.010	2.199	~		11	11
4.31	+/-0.030	4.314	~		Vern	6 A-01
1.50	+/-0.030	1,508	1		11	11
Ø1.300	+0.005/-0.000	41.305	1		f t	11
1.400	+/-0.010	1.399	~		4	11
0.635	+0.010/-0.000	0.640	~		"	"
0.750	+/-0.010	0.753	-		u ·	, /
0.200	+/-0.010	0.202			16	()
Ø0.750	+0.010/-0.000	6.753			1(• 1
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Measured by: \(\beta \beta \)	Audited by: Onl	Prototype Approval:	N/A
Date: 05 9	Date: 1/05/19	Date:	N/A

Rev	Date	Change .	Revised by	Approved
Α	05.04.26	New Issue	KJ/JLM 1,A	
В	08.09.09	Dimensions revised	KJ/DD K	

